

# Work Order ID 53128

October 23, 2009 8:00:49 AM



Page 1

Item ID:	D2989-13	Accept		Setup	Start	
Revision ID:	D				Stop	
Item Name:	Rib					
Start Date:	23/10/2009	Start Qty: 4.00		Cust Item ID:		
Required Date:	30/10/2009	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>PL</u>	Date:	<u>09-10-23</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2989	Rev D								
100	Large Fab	0.00							
	Large Fab	0.00							
Large Fab	Memo								
Large Fab	1- pick D3166-3 to cut D2989-13 rib as per dwg D2989 using DT9443 jig□2- remove identification markings□3- deburr								
110	QC5- Inspect part completeness to step on W/O	0.00							
	QC	0.00							
QC	Memo								
Quality Control									
120	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
	Packaging	0.00							
Packaging	Memo								

SAD 09-11-05

2) 8 or 16

(X) f

SAD 09-11-06

(4)

**Work Order ID 53128**

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Item ID: D2989-13

Accept



Setup Start



Revision ID: D

Stop



Item Name: Rib

Start Date: 23/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/06

MF

09-11-06

# Picklist Print

October 23, 2009 8:00:55 AM

Page 1

Work Order ID: 53128

Parent Item: D2989-13RevD

Parent Item Name: Rib

Comments:

Start Date: 23/10/2009

Required Date: 30/10/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3166-3RevA1

Manufactured

No

100

Each

11.6210

0.7579



SAD 09-11-05

Basket Hoop

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

11.621

50033

0.0527

50618

0.5683

51249

5

52058

6

0.7579

**D2989-043 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

**D2989-041 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 53128

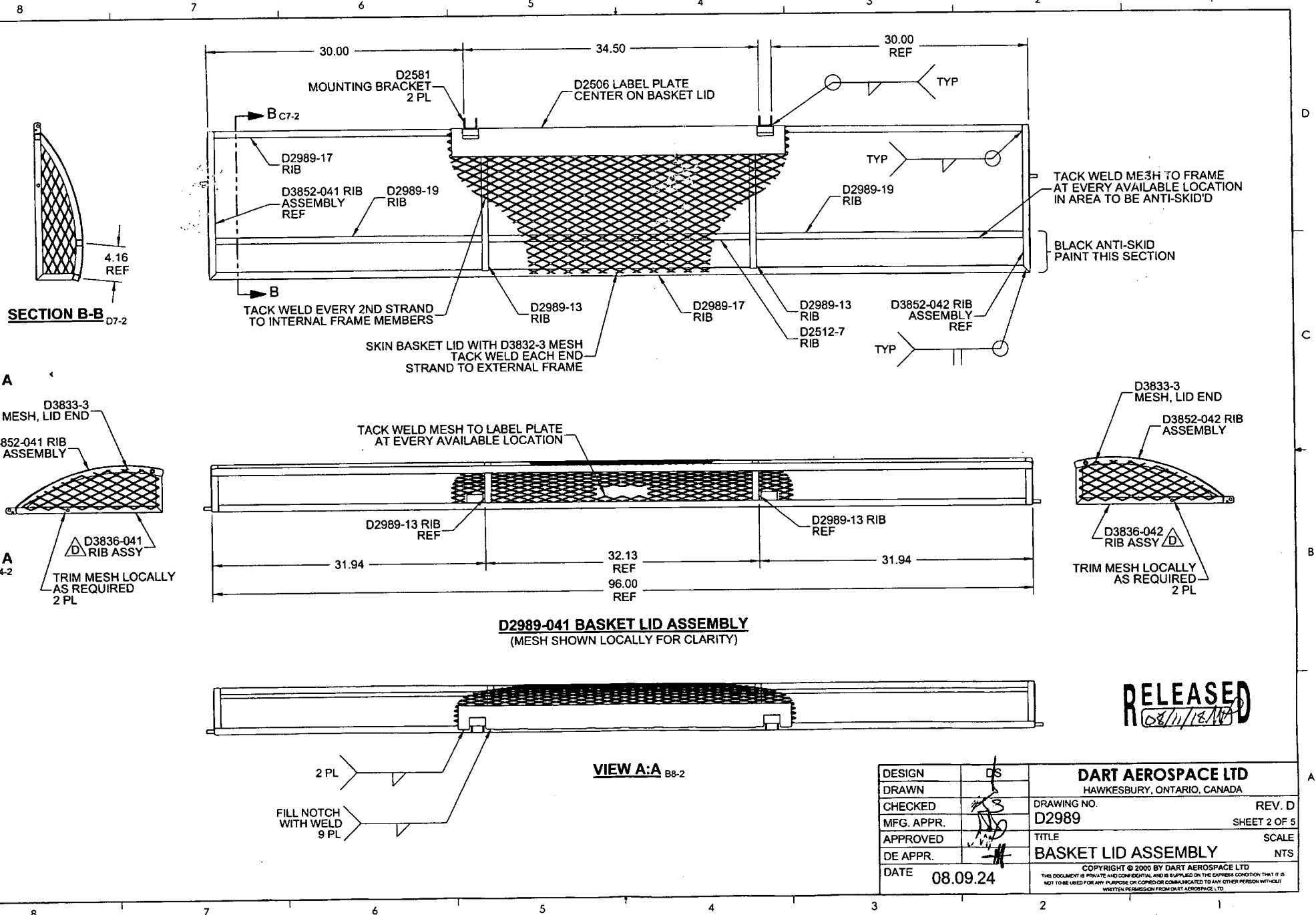
NOTES:  
MATERIAL: N/A  
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID  
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
UNITS: INCHES UNLESS OTHERWISE NOTED  
BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
IDENTIFICATION: N/A  
WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs  
WELD PER DART QSI 004

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED  
08/11/16

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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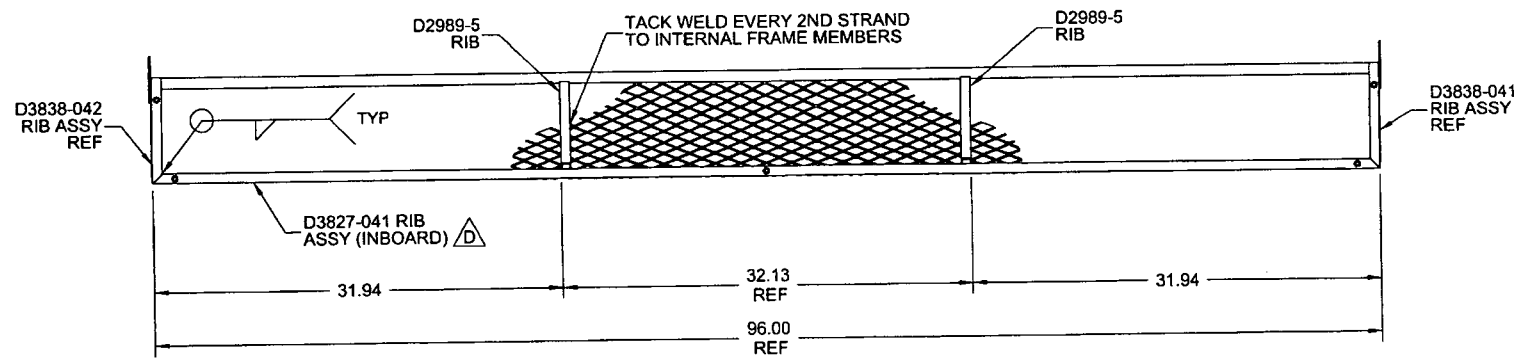
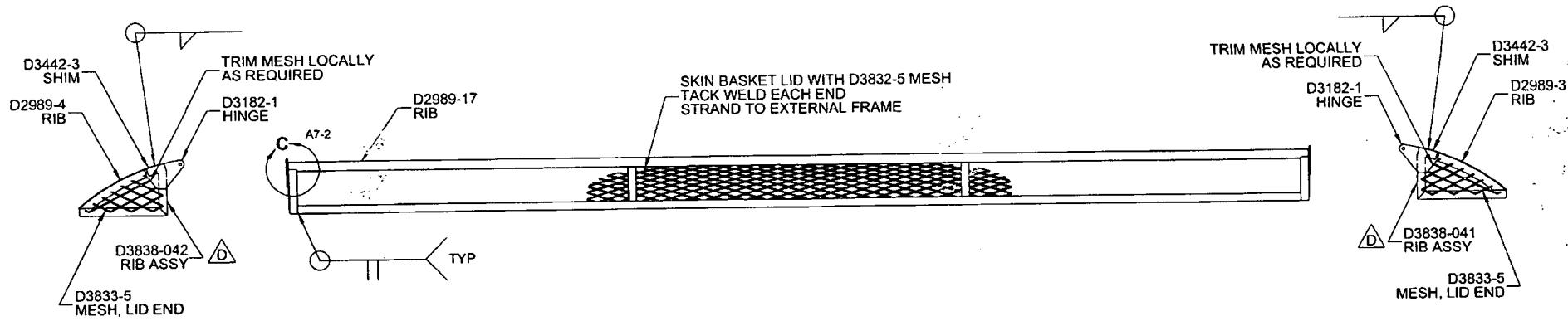


**D2989-041 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

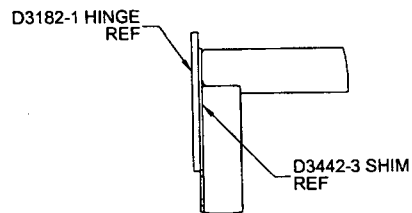
**VIEW A:A** B8-2

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO. <b>D2989</b>	REV. D
MFG. APPR.		SHEET 2 OF 5	
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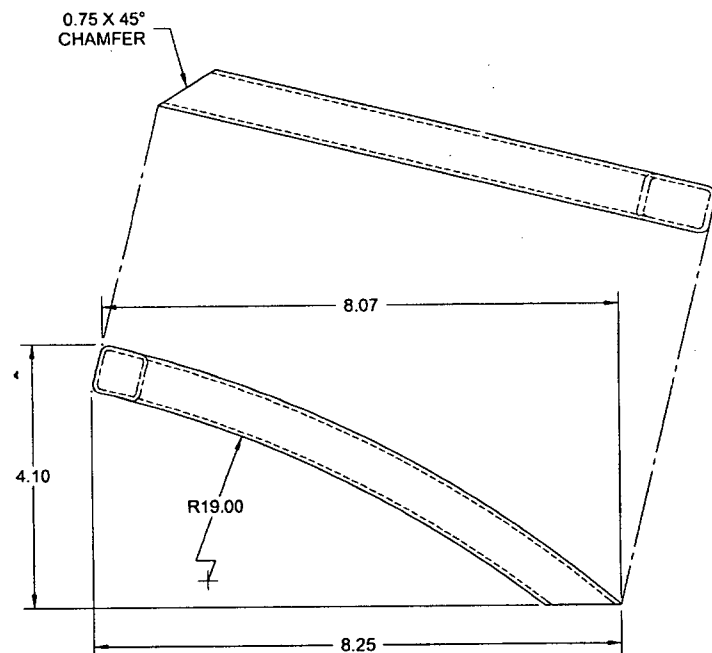
**D2989-043 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)



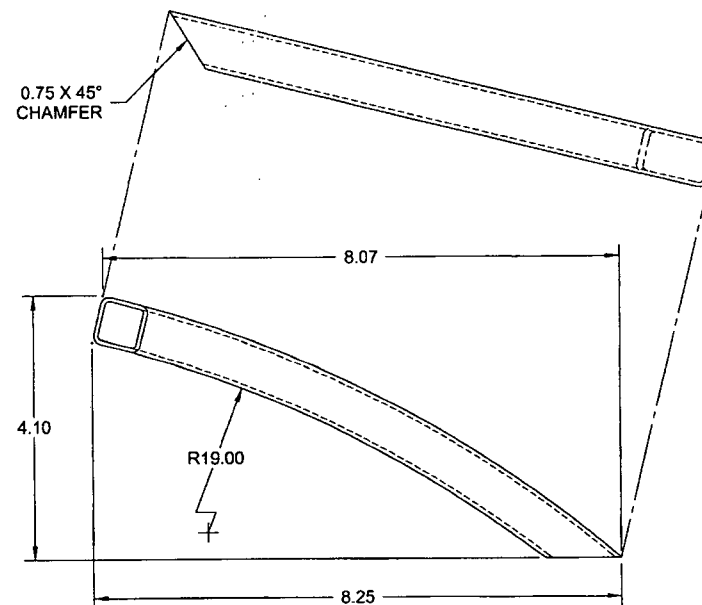
RELEASED  
08/11/18

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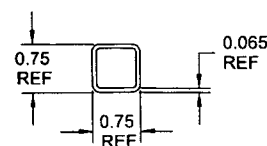
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**D2989-3 RIB**



**D2989-4 RIB**



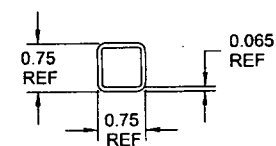
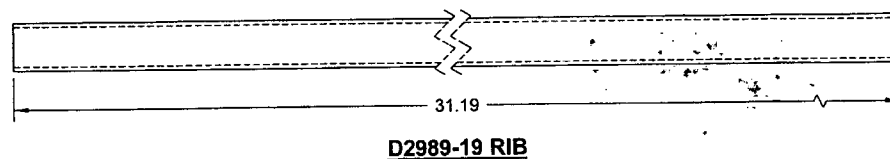
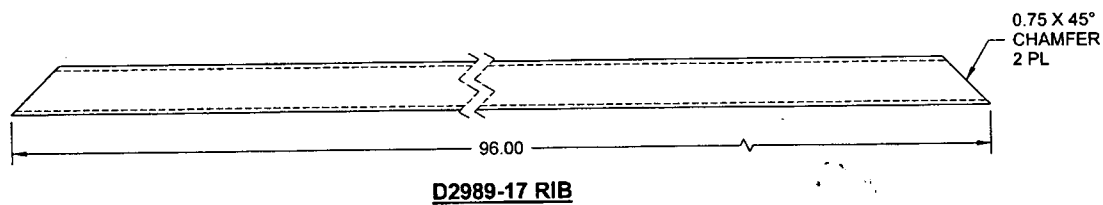
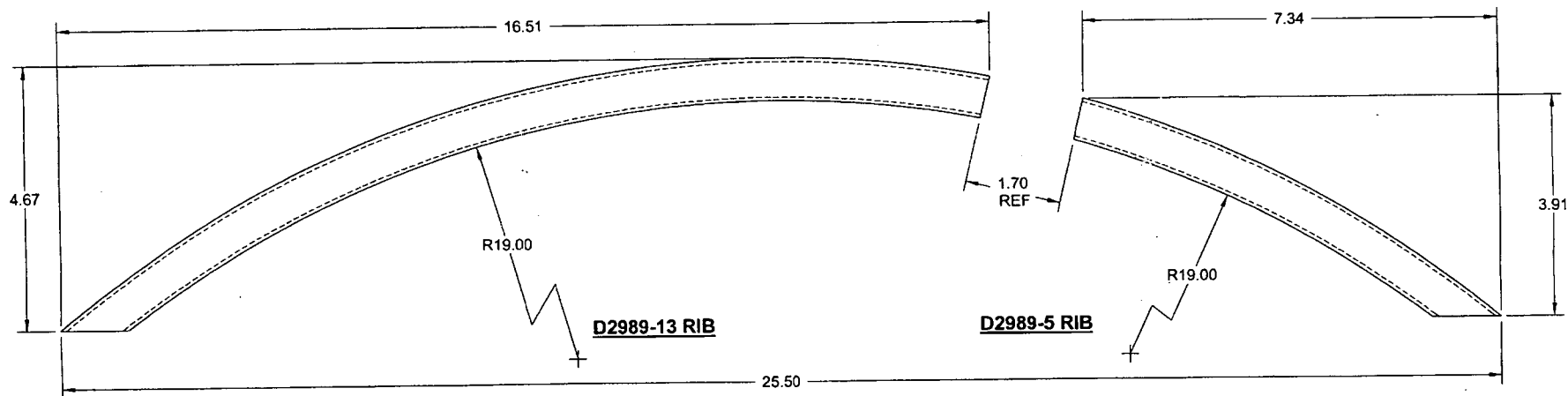
**TYPICAL SECTION  
VIEW**

- NOTES:
- 1 MATERIAL: D3166-3 BASKET HOOP
  - 2 FINISH: NONE
  - 3 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4 UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5 BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6 IDENTIFICATION: N/A
  - 7 WEIGHT: D2989-3/-4 = 0.39 lbs;

**RELEASED**  
08/11/18

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CHECKED		DRAWING NO.	REV.
MFG. APPR.		D2989	SHEET 4 OF 5
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**TYPICAL SECTION  
VIEW**

**RELEASED**  
08/11/18

**NOTES:**

1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
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MFG. APPR.			SHEET 5 OF 5
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